Work Order ID 93415-

Quality Control

93415

Page 1

November-19-12	2 10:05:17 A	IM		9.74	- 1:1						
Item ID: Revision ID:	D3889-041			Accept	*N900	040	100)* s	etup Star	*N	S1*
Item Name:	Panel, Floor								Sto	*N	S2*
Start Date:	11/15/12	Start Qty: 2.00	*2*		Cust Item I	D:			Ŷ		43
Required Date: Reference:	11/30/12	Req'd Qty: 2.00	*2*		Customer:						
Approvals:	Process Pl	an: MLJ	Date: 12-11-Ze	Tooling:	Da	ate:		R	un Star	t *N	R1*
	QC:		Date:	SPC (Y/N):	Da	ate:			Sto	*N	R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Re	vision Nbr									
D3889	Α										
100				0.00							
100 Waterjet		Memo		0.00				2	0		Jm12-11-2
Lexa 125 FG0029		1-Cut as pe Dwg Rev:_ Prog Rev:_	r Dwg D3889-1								
		2-Deburr if	and the control of th								
110		QC2- Inspect parts off n	nachine FAI/FAIB	0.00							
110		Mama		0.00				2	0		JM15-11-2

		DQA: Date:
Vas / No	WORK OPDER NON-CONFORMANCE / LIDDATE	Taxon .

NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UP	DATE	QA Closed:	Date		
Work Ord Part I	No					Rework Skid-tube Crosstube Scrap Wachining Small Fab Thermoforming Finishing Work Order Update Large Fab Composite				Crosstube Small Fab Finishing Composite	Prod. Eng. Coor. Quality Rec/Store/Packaging Other			
Root					Desc	ription of work order update	774	nitial		tion	Sign &			
Cause	_	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desci	ription	Date	Verification	QC Inspector	
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved														
							AUL	T CATE	GORY		min yang	PRINCE DE		
Landi						General		1		1	7			
		Bending Centre No Cracks Crushed/C Cuffs Heat Trea Inspection	Crimped.		D/S	Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short			on Incomplete ions Incomplete/l nance led	Unclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other	
	F	Ripples in	Bend			Drill Holes		Offset			a Sura Pi	distribute the		
i i	T	orque W	aves in E	xtrusion	1	Drawing		Out of C	alibration		- 45			
	T	urning Se	equence			Finish		Out of S	equence		15.3	A STAN IN COLUMN		

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Wave/Twist in Tube

Folio

Work Ord				*934	115*			Page 2
Item ID: Revision ID: Item Name:	D3889-041 Panel, Floor			Accept	*N9000401	NN*	Setup Start Stop	14.51
Start Date: Required Date Reference:	11/15/12 :: 11/30/12	Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*		Cust Item ID: Customer:			
Approvals:	Process Pla	an:	Date:	Tooling: SPC (Y/N):	Date:		Run Starr Stop	"INK I"
Sequence ID/ Work Center 120 *120* QC Quality Control	ID	Operation Description QC8- Inspect parts - seco	nd check	Set Up/ Run Hours 0.00 15 0.00 15 13.	Tool ID Tool # Ple	an Accepode Qty	et Reject Qty	Reject Insp. Number Stamp
120 Small Fab Small Fab 140 *120* Packaging Packaging		Memo Deburr if ne Pick Kit Memo	cessary	0.00		- (72-11 FF

FF 13.01.02

											DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-C	10	NFORM	MANCE / UPDATE				11 .
											QA Closed:	Date:	A Section of the Sect
Work Ord	er:			-1		DISPOSITION			AGAINS	T DE	PARTMENT/	PROCESS	
Part NCR	No.					Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Crosstub Machining Small Fa noforming Finishin Large Fab Composit	b g	Feb. 100 C	Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
Root						ption of work order update		Initial	Action		Sign &	C MAN TO A STATE OF	
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved								N. W.					
Ē-	N 5-2						AUL	T CATE	GORY		100		
Landi		Bending				Generali Bend		Grain			Ovalized		Pressure/Forced
E	H	Centre No	t Concer	itric to	0/5	BOM/Route		Hardwa			Over/Under	HOLDEN COLUMN	Temperature/Cure
Ę.	H	Cracks			-	Broken/Damaged			on Incomplete	-	Part Incorred		Weld
100	-	Crushed/0	rimped.		-	Burrs		1	ons Incomplete/Unclear	-	Part Lost/Mi	ssing	Wrong Stock Pulled
	-	Cuffs				Contamination		Mainte			Part Moved		
2	-	Heat Trea				Countersink		Mislabe		-	Positioned V		7
-	-	Inspection		Tube		Cut Too Short		Misread		L	Power Loss/	Surge	Other
		Ripples in	Bend			Drill Holes		Offset					

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

Work Order ID 93415 *93415* Page 3 November-19-12 10:05:17 AM *N900040100* D3889-041 Accept Setup Start Item ID: Revision ID: Stop Item Name: Panel, Floor Start Qty: 2.00 Start Date: 11/15/12 Cust Item ID: *2* Required Date: 11/30/12 Req'd Qty: 2.00 Customer: Reference: Start Run Tooling: Date: Date: Approvals: Process Plan: Stop SPC (Y/N): Date: QC: Date: Reject Tool ID Tool # Accept Reject Insp. Sequence ID/ Operation Set Up/ Plan Qty Qty Number Stamp Work Center ID Description Run Hours Code 0.00 150 *150* 0.00 Small Fab Memo Small Fab 1- Bond gasket to smooth side of panel as per dwg A/R 3M 1300 adhesive Batch: 123 55 Z 160 QC5- Inspect part completeness to step on W/O *160* Memo Quality Control 170 Identify as per dwg & Stock Location: 0.00

0.00

Memo

170

Packaging

Packaging

PPP 350-7660021

13-01-03

			DQA
NCR:	Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE	

DQA:	Date:	1 9
THE RESERVE OF THE PARTY OF THE		311

-											QA Closed:	Date	Car 25	
Work Ord	er:					DISPOSITION				AGAINST DE	PARTMENT,	/PROCESS		
Part I	No		7.			Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstub Machining Small Fa Thermoforming Finishin Large Fab Composit			ab Prod. Eng. Coor. Quality ing Rec/Store/Packaging Other			
Root					Descri	ption of work order update	Ir	nitial	Ac	tion	Sign &			
Cause		Date	Step	Qty		or Non-conformance	Chi	ef Eng	Desc	cription	Date	Verification	QC Inspector	
Doc/Data Equip/Tooling Operator Miaterial Setup Other Process Supplier Training Unapproved							_	7.Å/						
	N 25						AULT	CATE	GORY		all applicati	# * wild 3 3		
Landi						General				-	-	Year State 2		
	\vdash	lending				Bend	\vdash	Grain			Ovalized		Pressure/Forced	
		entre No	t Concer	tric to	0/5	BOM/Route	-	Hardwa		- 9	Over/Under		Temperature/Cure	
	\vdash	racks	- Daniel - G		-	Broken/Damaged	-	7.0	on Incomplete		Part Incorred		Weld	
		rushed/0	rimpea.		-	Burrs	-		ons Incomplete	/Unclear	Part Lost/Mi	issing	Wrong Stock Pulled	
Production of	-	uffs leat Trea			-	Contamination	_	Mainte			Part Moved			
1	$\overline{}$	reat Trea respection		Tuba	-	Countersink Cut Too Short	-	Mislabe Misread		100	Positioned V		Jour	
2-		ipples in		Tube		Drill Holes	-	offset		L	Power Loss/	ourge	Other	
Je in	-	orque W		ytrusio	_	Drawing	-		alibration		11:45		AST WAS	
=		urning Se		ati usioi		Finish	-		equence		TAN SET			
e e		Vave/Twi		P		Folio			Dimensions			West Strain	2 iii	
In from to to				(A) CO) A (1.5.10		- utiluc	CHITCHISTOTIS		1.7		170	

Work Order ID 93415

93415

Page 4

November-19-12 10:05:17 AM

Item ID:

D3889-041

Accept

N900040100

Setup Start

Revision ID:

Start Date:

Item Name:

Required Date: 11/30/12

Panel, Floor

11/15/12

QC:

Start Qty: 2.00

2

Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Date:

Date:

Tooling:

Date: Date: Run Start

Stop

Stop

Sequence ID/

Work Center ID

Operation Description

Req'd Qty: 2.00

QC21- Final Inspection - Work Order Release

Set Up/ Run Hours

SPC (Y/N):

Tool#

Plan

Accept Code Qty

Reject Qty

Reject Number Stamp

Insp.

180

QC

180

Memo

0.00

0.00

Quality Control

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA:	Date:	

			K FILE							1.0	QA Clo	sed:	Date	e: .	
Work Orde	er:					DISPOSITION				AGAINST D	EPARTM	ENT/	PROCESS		
Part I	Part No. NCR No.					Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite			Prod. Eng. Coor. Quality Rec/Store/Packaging Other				ngineering Quality Other
Root					Descri	ption of work order update	Ini	itial	Ac	tion	Sign	&	har hear		View Teach
Cause		Date	Step	Qty	C	or Non-conformance	Chie	f Eng	Desc	cription	Dat	e	Verification		QC Inspector
Doc/Data											- 23	W	A SHI THE		13
Equip/Tooling															
Operator												4			
Material												10			- 1
Setup												調		900	
Other															
Process	_											16		ál -	-9
Supplier															
Training Unapproved	-												The same	1	
Unapproved						-	ALILT	CATE	OPV		100	-100-0	William St. Co.	2 10	
Landi	na C	Sear				General	HULI	CATEC	JORT		375			119	100
Landi		Bending				Bend		irain		Г	Ovalize	d		Pro	essure/Forced
6	$\overline{}$	Centre No	t Concer	atric to (0/5	BOM/Route	\vdash	ardwai	ne	1			colerance	_	mperature/Cure
	-	Cracks				Broken/Damaged	\vdash		on Incomplete		Part Inc			We	
	-	Crushec/C	rimped			Burrs	-	100	ons Incomplete/	Unclear	Part Lo		The second of the second	-	rong Stock Pulled
	-	Cuffs	•			Contamination	$\overline{}$		nance		Part Me				ong otoes runes
	-	Heat Treat	t			Countersink	\vdash	1islabe		1	Position		rong		
9		Inspection	Strip in	Tube		Cut Too Short	\vdash	lisread			Power			Ot	her
	_	Ripples in				Drill Holes	$\overline{}$	ffset		L					3
		Torque Wa	aves in E	xtrusion		Drawing		ut of C	alibration		-	-12/29		MI B	
		Turning Se	equence			Finish	0	ut of S	equence				STILL STATE OF	1	1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1
the second		Mana/Tari	ct in Tub			Folio		uteida	Dimonsione		37	1100	PART OF THE PART OF	15	7 7 7 7 7 7 7 7 7 7 7 7 7 7 7 7 7 7 7 7

Picklist Print

November-19-12 10:05:17 AM

Work Order ID:

93415

Parent Item:

D3889-041

Parent Item Name:

Panel, Floor

Start Date: 11/15/12

Required Date: 11/30/12

Page 1

Start Qty: 2.00

Required Qty: 2.00

-				281	
C	OF	nn	lei	its	1

IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04 GE PLASTICS LEXAN S	HEET	Purchased	No			100	sf	734.5384	8.1925	17.247368			JM12-11-25
				Location		Loc Qty	Lo	c Code					
				MAT018		734.5384							
				121	803	734.5384			191	803			
D3889-3 Gasket		Manufactured	No			140	Each	2.0000	1	2	FF	12	-11-26
Cusaci				Location		Loc Qtv	1.0	c Code			FF	01	-02-2013
				ST416		2							
				864	28	2							

NCR:	Yes / No				WORK ORDER NON-C	100	VFORM	MANCE / UPDATE				
-										QA Closed:	Date:	Ale
Work Order:				DISPOSITION		AGAINST DEPARTMENT/PROCESS						
Part No				Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstube Small Fab Thermoforming Finishing Composite		Prod. Eng. Coor. Rec/Store/Packaging Supplier		Engineering Quality Other		
Root				Descri	ption of work order update	1	nitial	Action	112	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Doc/Data Ecuip/Tooling Operator Material Setup Other Process Supplier Training Unapproved												
FAULT CATEGORY												
Centre Not Concentric to O/S				General Bend BOM/Route Broken/Damaged		Grain Ovalized Hardware Over/Under tolerance			SPANIA MILITER TO	Pressure/Forced Temperature/Cure		
B.,	Cracks				proken/Damaged		Inspecti	on Incomplete	1.53	Part Incorred	3 3 3 3 3 3 3 3 3 3 3 3 3 3 3 3 3 3 3 3	Weld

Instructions Incomplete/Unclear

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

DQA:

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Part Moved

Wrong Stock Pulled

Other

Date:

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Crushed/Crimped

Inspection Strip in Tube

Torque Waves in Extrusion

Cuffs

Heat Treat

Burrs

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order:	93415	
Description: Panel	Part Number:	D3889-1	
Inspection Dwg: D3889 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prototype	
		West As a Constitution of the Constitution of	

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Com	ments
1.88	+/-0.030	1.88"	=		J	Produ	SUZ
34.0	+/-0.100	34.0"	/		T	Produ	
27.35	+/-0.030	27.35	S=2		T		
8.37	+/-0.030	8.37") —		V		
25.35	+/-0.030	25.35"	-		T		
27.77	+/-0.030	27.77	-		T		
34.7	+/-0.100	34.7"	-		T		-
14.30	+/-0.030	14.30	-		T		
20.56	+/-0.030	20.56"	-		T		
24.02	+/-0.030	24.02"	-		T		
23.23	+/-0.030	23.23"	J.		T		
0.125	+/-0.010	0.126"			٧	71.5	
							······································
							er 10
			15				

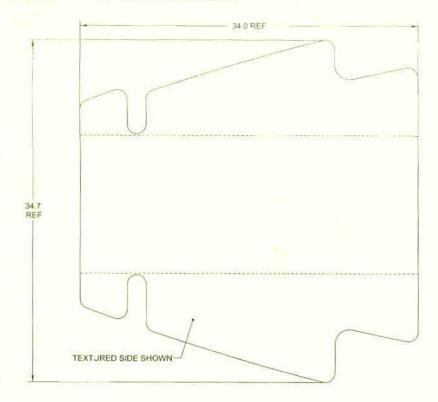
Measured by:	Jm	Audited by:	5	Prototype Approval:	N/A	
Date:	12-11-25	Date: /j	1126	Date:	N/A	

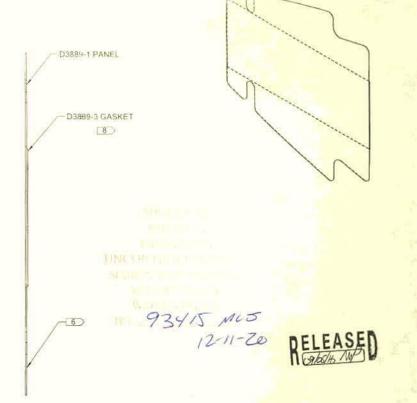
Rev	Date	Change		Revised by	Approved
A	09.07.29	New Issue	P/O D3889-041	KJ P	





ITEM.	QTY -041	DIN	DESCRIPTION
1	×	D3889-041	PANEL FLOOR
2		D3889-1	PANEL
3	- 1	D3889-3	GASKET
4	A/R	3M 1300	ADHESIVE





D3889-041 PANEL, FLOOR

1) MATERIAL: N/A 2) FINISH: NONE

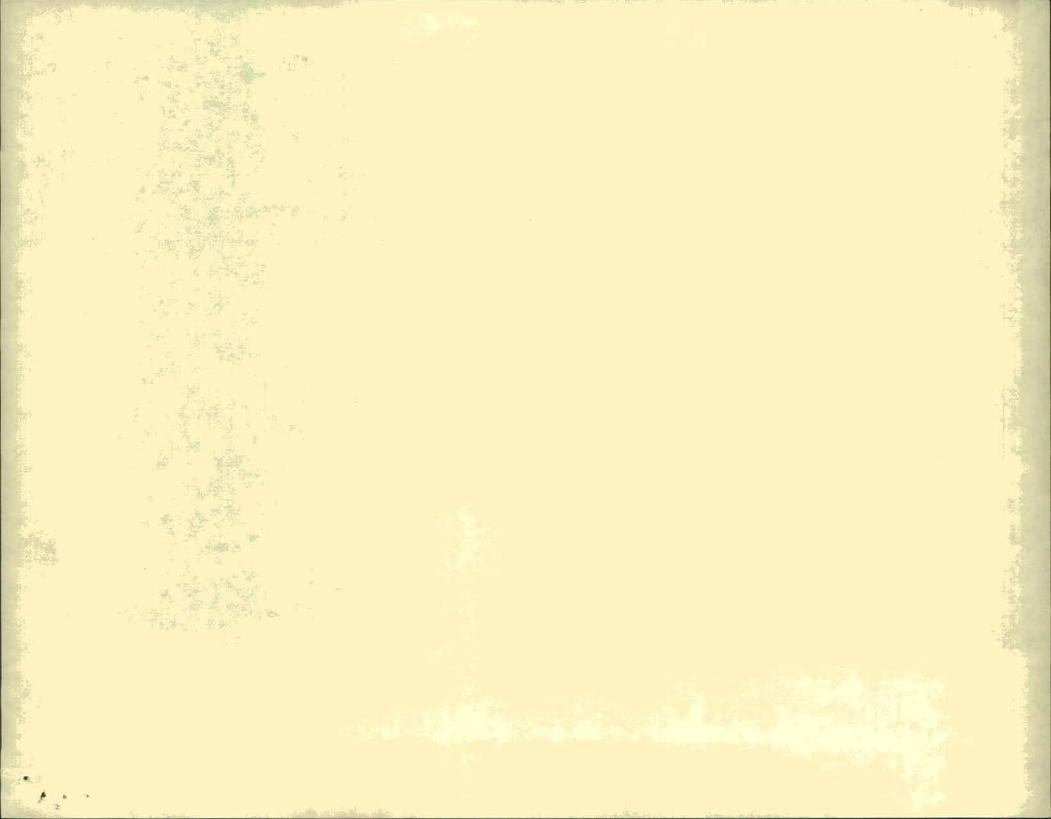
8

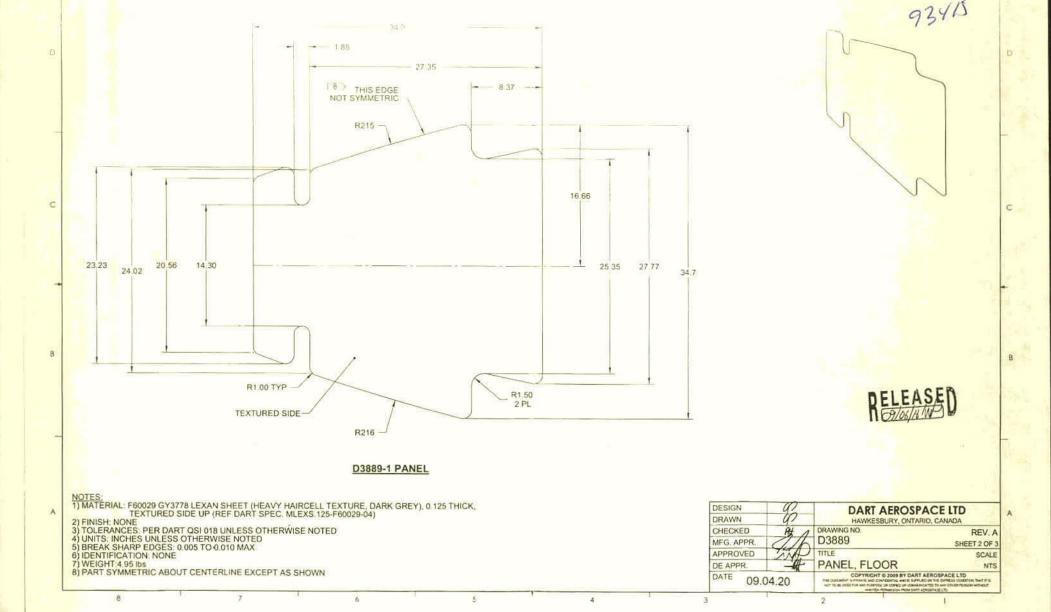
3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: NONE

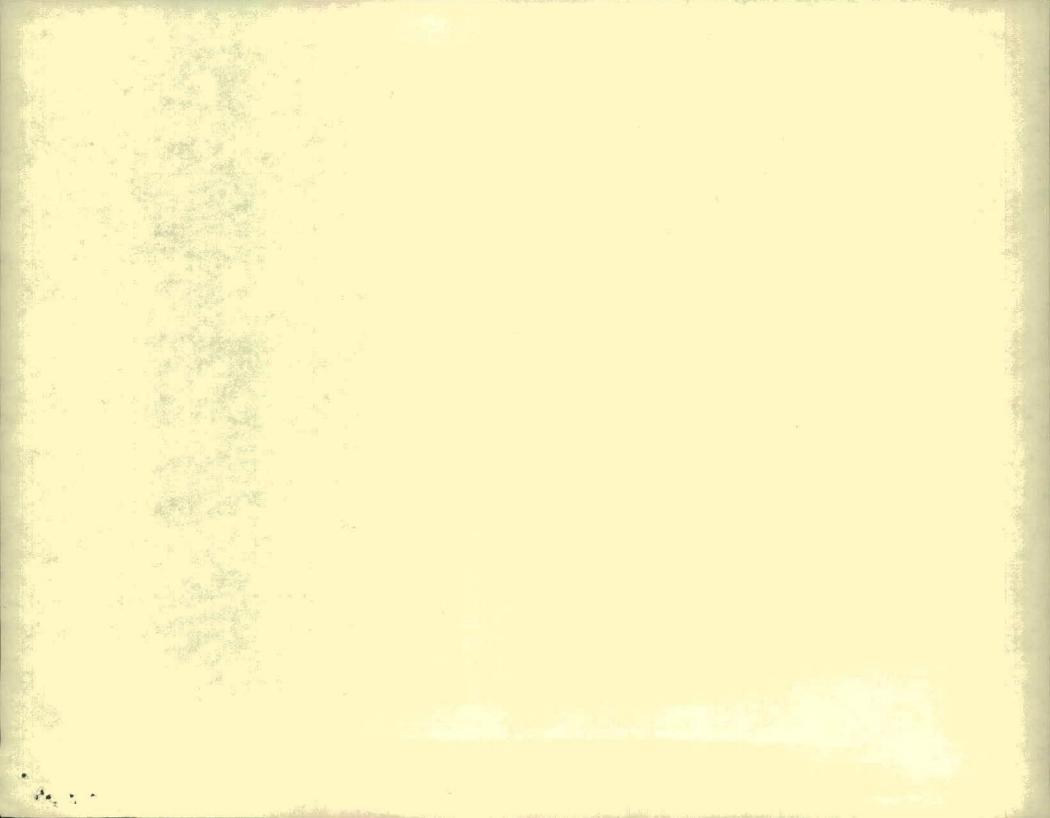
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3889-041" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH/UNTEXTURED SIDE OF PART

B) BOND GASKET TO SMOOTH/UNTEXTURED SIDE OF PART USING 3M 1300 ADHESIVE. TRIM GASKET TO EDGES OF PANEL, IF REQUIRED.

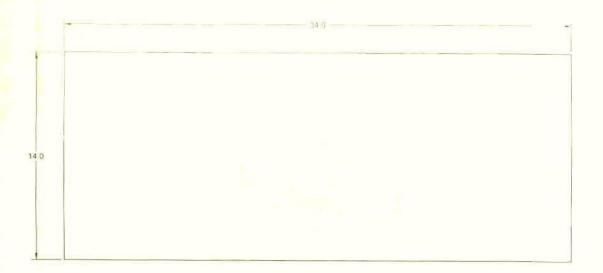
A NEW ISSUE 09.04.20 REV. DESCRIPTION BY DATE DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. A D3889 MFG. APPR. SHEET 1 OF 3 APPROVED TITLE SCALE PANEL, FLOOR DE APPR NTS DATE COPYRIGHT © 2009 BY DART AEROSPACE LTD
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NOT TO BE URBS FOR ANY PURPOSE ON COMPENSATION OF ANY OWNERS HOW 09.04.20







93415



D3889-3 GASKET



NOTES:
1) MATERIAL: NEOPRENE FOAM SHEET, 0.125 THICK
(REF DART SPEC. M4111N-S.125)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: NONE
8) IDENTIFICATION: NONE

6) IDENTIFICATION: NONE 7) WEIGHT: 0.19 lbs

DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. A D3889 MFG. APPR. SHEET 3 OF 3 APPROVED TITLE SCALE PANEL, FLOOR DE APPR NTS COPYRIGHT © 2008 BY DART AEROSPACE LTD

THE DOCUMENT ARE OPPOSITED, AND A SUPE SET HE SPECIAL CONCIDENT THAT IT AND TO SET HE ARE OPPOSED ON COMES OF COMMON THE SET OF OPEN OF COMES OF COMMON THE SET OF COMES OF COMES OF COMMON THE SET OF COMES O 09.04.20

